

SPLIT

Date: Wednesday, 1/23/2008 11:31:33 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	TUNNEL BOTTOM PANEL		
Job Number	36911 -2						
Estimate Number	13026						
P.O. Number				Part Number	D3649041		
This Issue	1/23/2008	S.O. No.		Drawing Number	D3649 REV.B U/R		
Prsht Rev.	NC			Project Number	N/A		
First Issue	/ /	Type	SMALL /MED FAB	Drawing Revision	B U/R		
Previous Run	35710			Material			
Written By				Due Date	2/29/2008	Qty:	
Checked & Approved By						Um:	Each
Comment	Est Rev:A New Issue 07-09-26 EC verified by: DD Est Rev:B ECN 1113P 08-01-22 DD						

PF 08.07.10



Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S26GA	304/316 0.018 SHEET
	Comment: Qty.: 6.3725 sf(s)/Unit Total : 12.7449 sf(s) 304/316 SS sheet 26 ga (0.018" thick) Batch: 104946 B 8-2-4	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3649 Dwg Rev: B B 8-2-4 Prog Rev: B	(2)
	2-Deburr if necessary B 8-2-4	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE B 8-2-4	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK B 8-2-4	(2)
5.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE Form as per Dwg D3649	



Job Number: 36911

Part Number: D3649041

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP <i>Sod 216 ②</i>
7.0	MS210603K	Nut Plate <i>08/07/16 25</i>
	Comment: INSPECT WORK TO CURRENT STEP	
8.0	MS210623K	Nut Plate <i>25 SB</i>
	Comment: Qty.: 22.0000 Each(s)/Unit Total : 44.0000 Each(s) Nut Plate	<i>M105933 M106946</i>
9.0	MS20427M33	Nut Plate <i>86 09/07/16 18</i>
	Comment: Qty.: 22.0000 Each(s)/Unit Total : 44.0000 Each(s) Nut Plate	<i>* MM105933</i>
10.0	SMALL FAB 1	Rivet <small>SMALL & MEDIUM FAB RESOURCE 1</small> <i>SB * 08/07/16</i>
	Comment: SMALL & MEDIUM FAB RESOURCE 1	
	1- Form dimple for MS20427M3 rivet per dwg D3649 *****ensure dimples are on the proper side***** 2-Assemble nutplates as per dwg D3649	<i>FF 08-07-16 08-07-16 ①</i>
11.0	QC5	INSPECT WORK TO CURRENT STEP ENGINEERING APPROVAL <i>PD 08-07-06</i> <i>08/07/16 ②</i>
	Comment: INSPECT WORK TO CURRENT STEP	
12.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>FF 08-07-30 ①</i>
	Comment: PACKAGING RESOURCE #1 Identify and stock Location: <i>39926-1</i>	



User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUNNEL BOTTOM PANEL

Job Number: 36911

Part Number: D3649041

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

Dcaloslo8

MF 08-08-01

Job Completion



POSITIVE RECALL

EFFECTIVE 08-06-31 AUTH URELEASED U DATE 080716



DART AEROSPACE LTD

Work Order:

36911

Description: TUNNEL BOTTOM PANEL

Part Number:

D3649-1

Inspection Dwg: D3649-1 Rev: 5

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.098	+.024 -.001	.099	X			
.196	+.005 -.001	.199	X			
.250	+.005 -.001	.254	X			
.400	+.010 -.010	.400	X			
.385	+.010 -.010	.385	X			
.750	+.010 -.010	.750	X			
44.57	+.030 -.030	44.57	X			
11.70	+.030 -.030	11.70	X			
33.70	+.030 -.030	33.70	X			
13.76	+.030 -.030	13.76	X			
4.300	+.010 -.010	4.300	X			
10.11	+.030 -.030	10.11	X			
12.90	+.030 -.030	12.90	X			
16.61	+.030 -.030	16.61	X			
15.80	+.030 -.030	15.80	X			
3.950	+.010 -.010	3.950	X			
.42	+.030 -.030	.42	X			
.41	+.030 -.030	.41	X			
.85	+.030 -.030	.85	X			
19.64	+.030 -.030	19.64	X			
.54	+.030 -.030	.54	X			
1.400	+.010 -.010	1.400	X			
2.63	+.030 -.030	2.63	X			

Measured by: B

Audited by: ✓

Prototype Approval:

Date: 8-7-4

Date: 08/02/04

Date:

Rev	Date	Change
A		New Issue

Revised by	Approved
KJ/JLM	



DART AEROSPACE LTD

Work Order: 36911

Description: TUNNEL BOTTOM

Part Number: D3649-1

Inspection Dwg:D3649-1 Rev: 6

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.93	+/- .030	2.91	X			
1.49	+/- .030	1.49	X			
5.98	+/- .030	5.98	X			
.54	+/- .030	.54	X			
2.70	+/- .030	2.70	X			
2.75	+/- .030	2.75	X			
2.48	+/- .030	2.47	X			
1.16	+/- .030	1.16	X			
3.38	+/- .030	3.375	X			
2.00	+/- .030	2.00	X			
.90	+/- .030	.90	X			
16.64	+/- .02	16.64	X			
.48	+/- .030	.48	X			
13.80	+/- .030	13.80	X			
.46	+/- .030	.46	X			
11.76	+/- .030	11.76	X			
1.23	+/- .030	1.23	X			
.88	+/- .030	.88	X			
18.46	+/- .02	18.46	X			
5.23	+/- .030	5.237	X			
1.933	+/- .010	1.933	X			
1.943	+/- .010	1.943	X			
5.02	+/- .030	5.02	X			

Measured by: FB
Date: 8-24

Audited by: J
Date: 08/04

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



DART AEROSPACE LTD	Work Order:	36411
Description: TUNNEL BOTTOM PANEL	Part Number:	D3649-1
Inspection Dwg: D3649-1 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	B	Audited by:	S	Prototype Approval:	
Date:	8-24	Date:	08/02/04	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



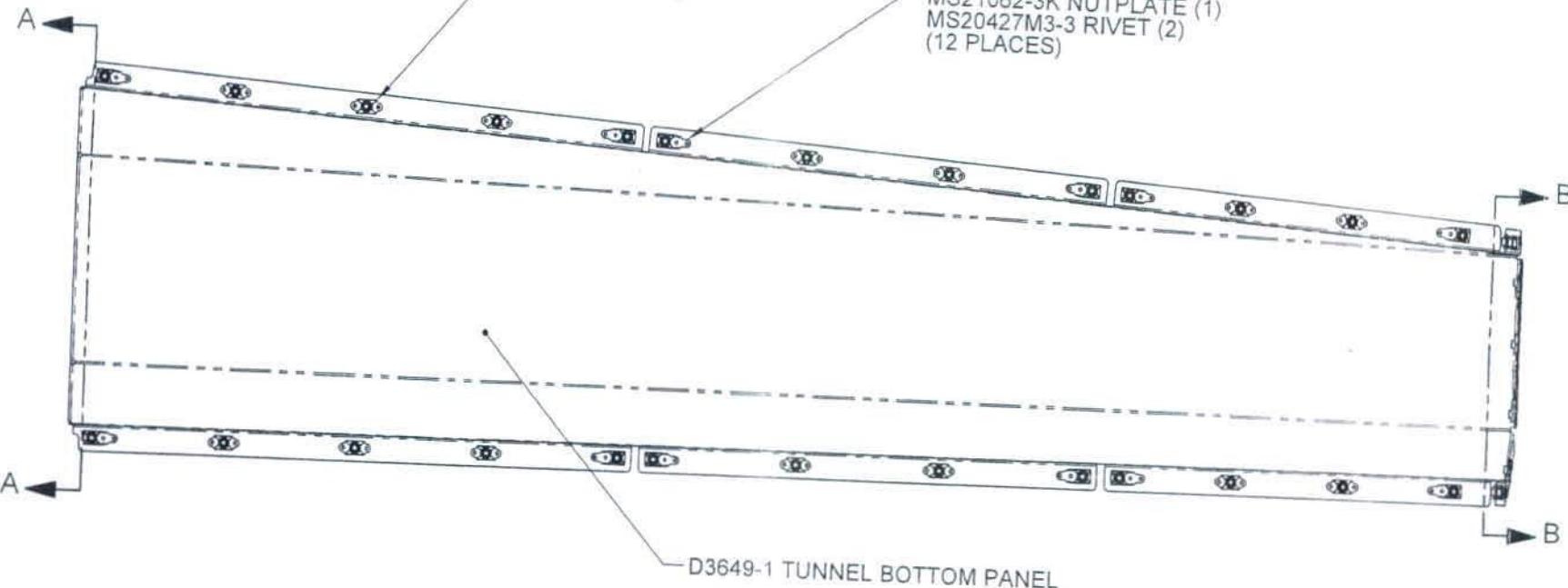


MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(5 PLACES)

MS21062-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(4 PLACES)

MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(14 PLACES)

MS21062-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(12 PLACES)



D3649-041 BOTTOM PANEL ASSEMBLY

DESCRIPTION
TUNNEL BOTTOM PANEL ASSY.
TUNNEL BOTTOM PANEL
RIVET
NUTPLATE
NUTPLATE

B	PAGE 3 MS20427M3 WAS MS20427M3	
A	NEW ISSUE	
REV.	DESCRIPTION	
DESIGN	RF	DAR
DRAWN	RF	HAWK

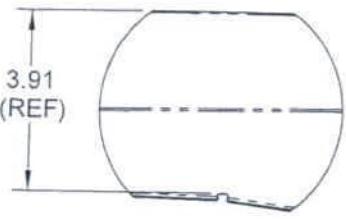
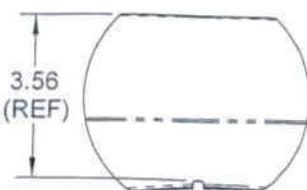
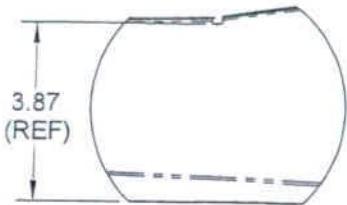
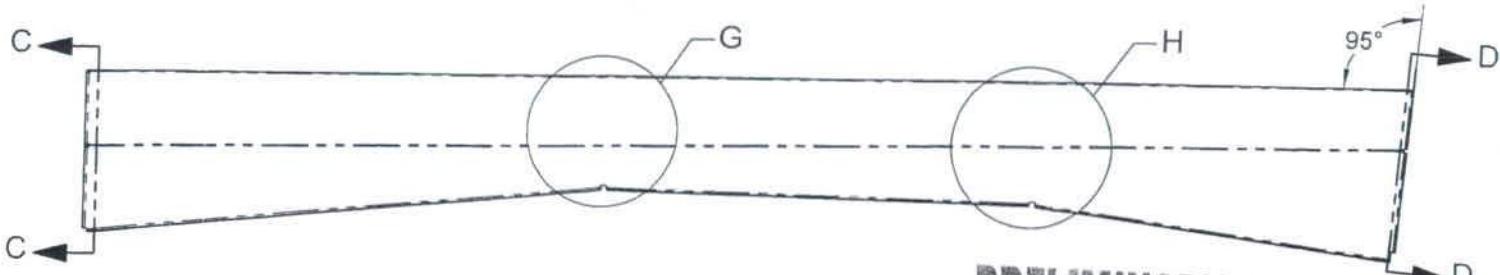
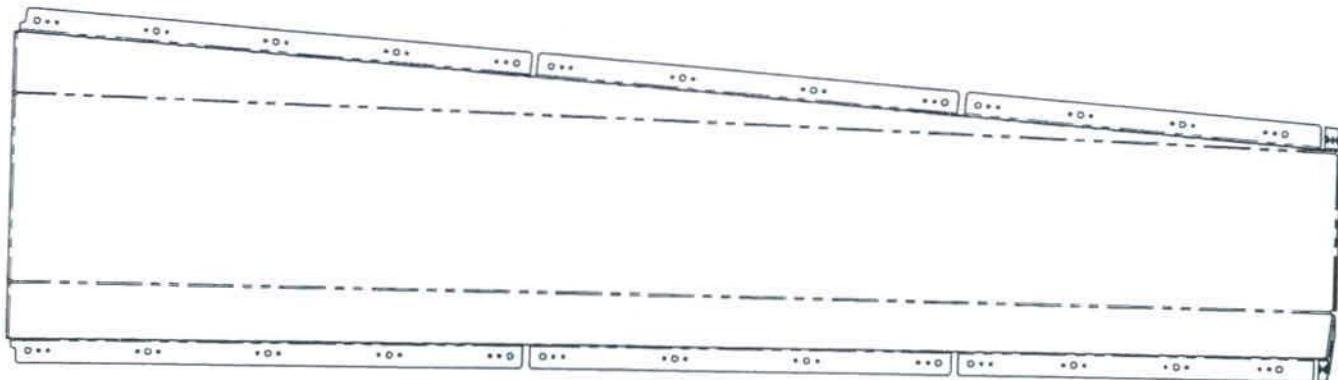
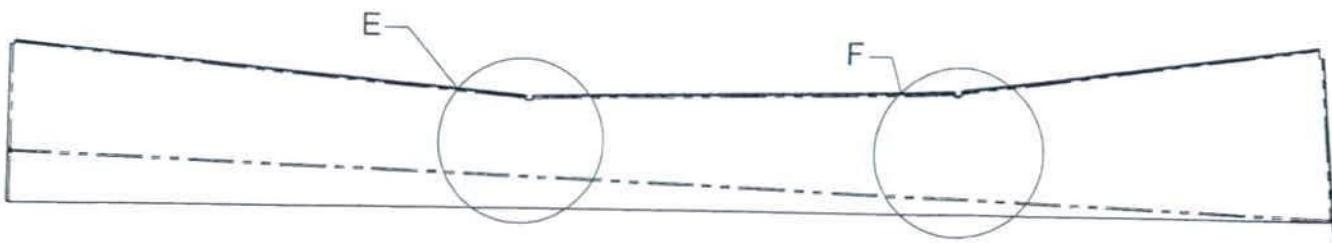


5

4

3

2

DETAIL EDETAIL FDETAIL GDETAIL H

PRELIMINARY ISSUE

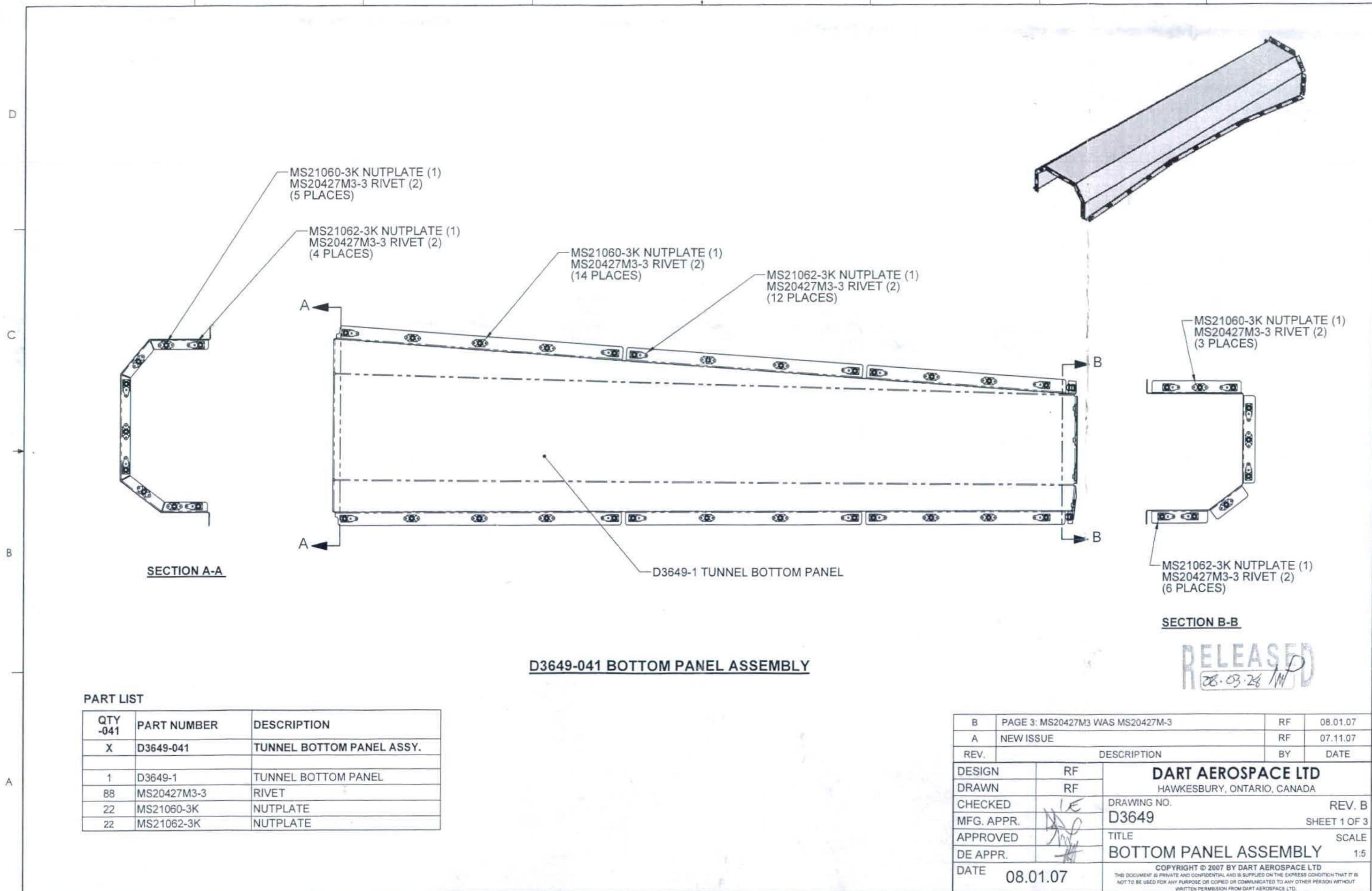
LE 08.01.08

EL BOTTOM PANEL
(ROM D3649-1F)

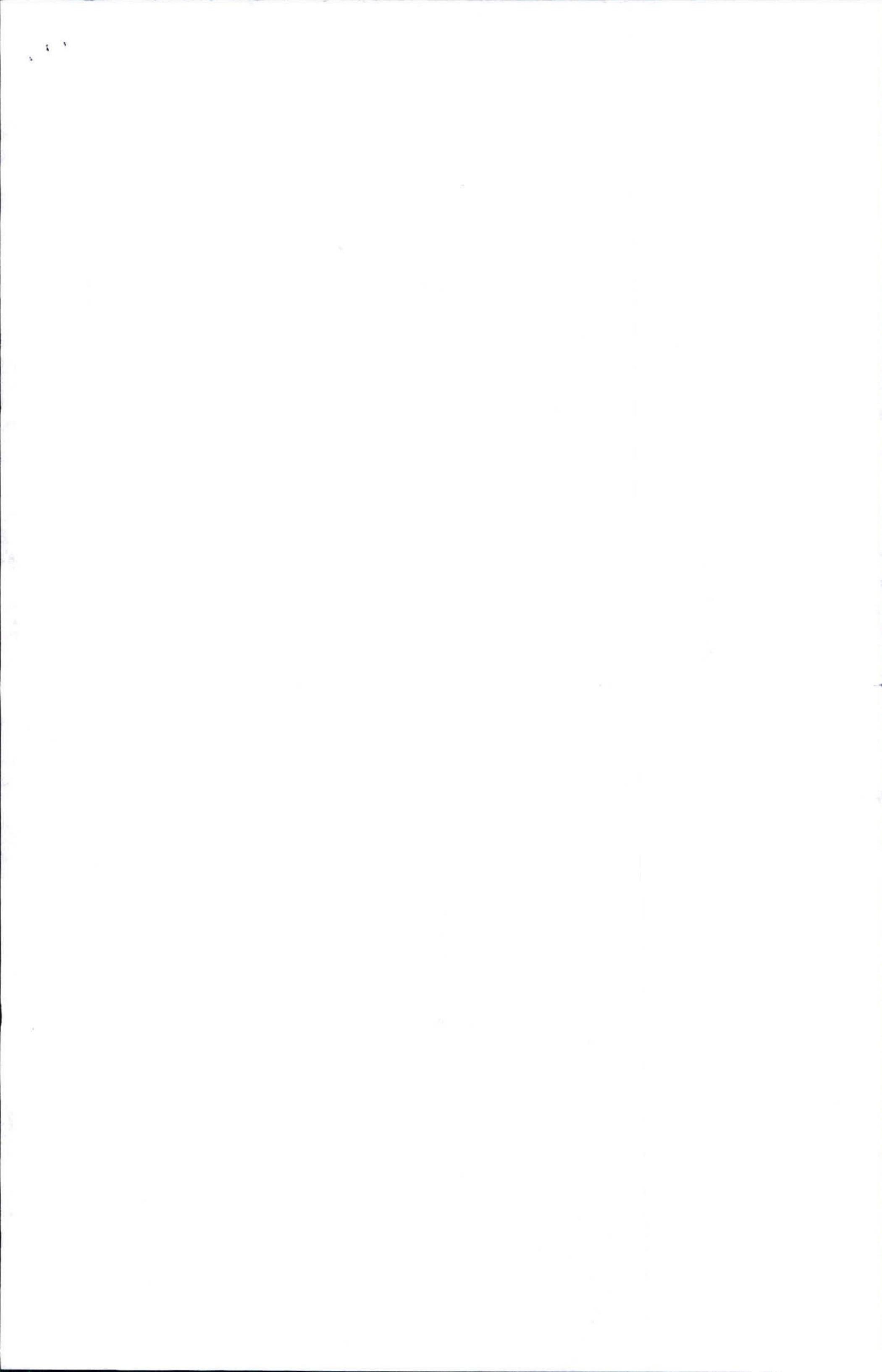
DESIGN	RF	DART AEROSPACE LTD.
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	LE	DRAWING NO.
MFG. APPR.	WJ	D3649
APPROVED	WJ	TITLE
DE APPR.		BOTTOM PANEL ASSEMBLY
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER WRITTEN PERMISSION FROM DART AEROSPACE LTD.



8 7 6 5 4 3 2 1

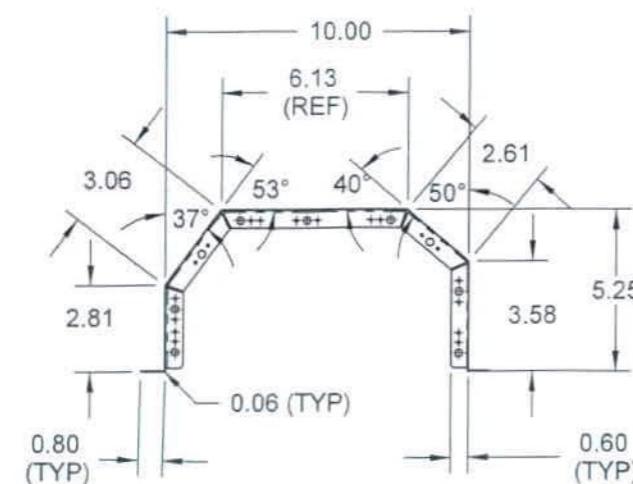


8 7 6 5 4 3 2 1



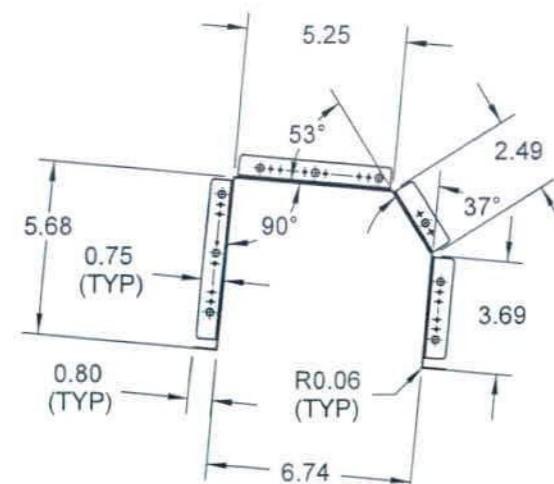
8 7 6 5 4 3 2 1

D



SECTION C-C

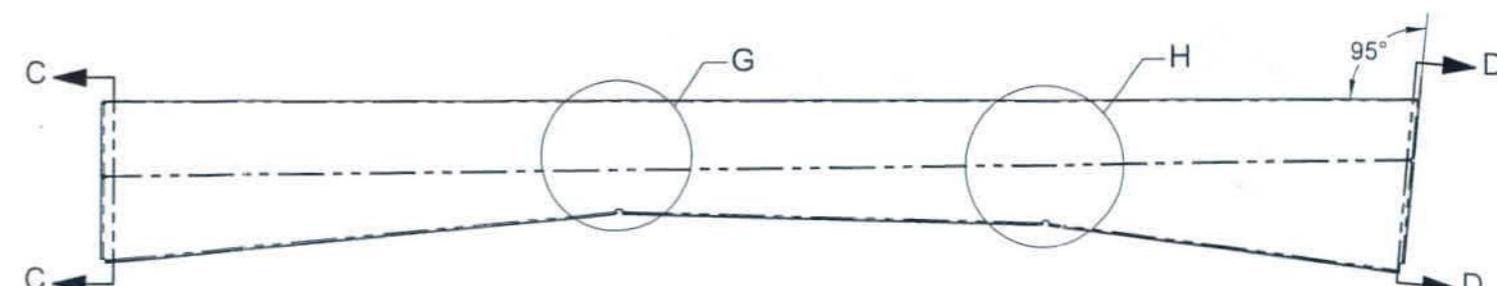
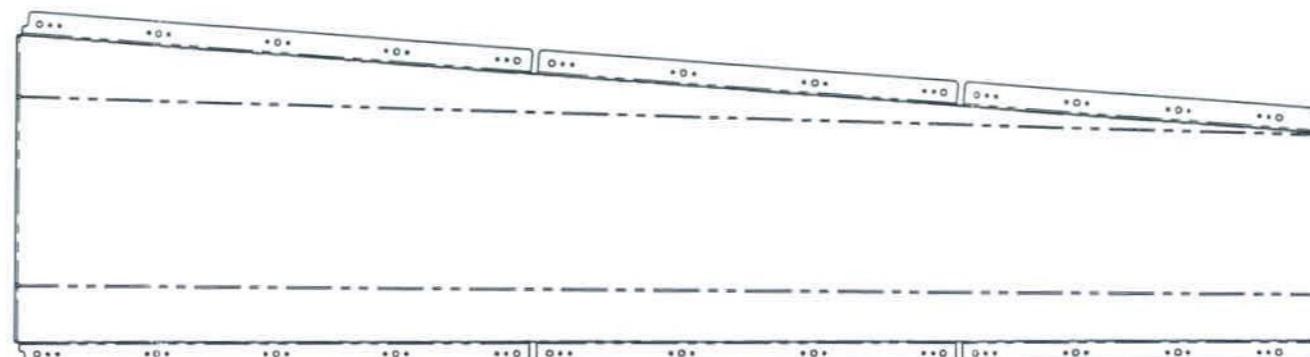
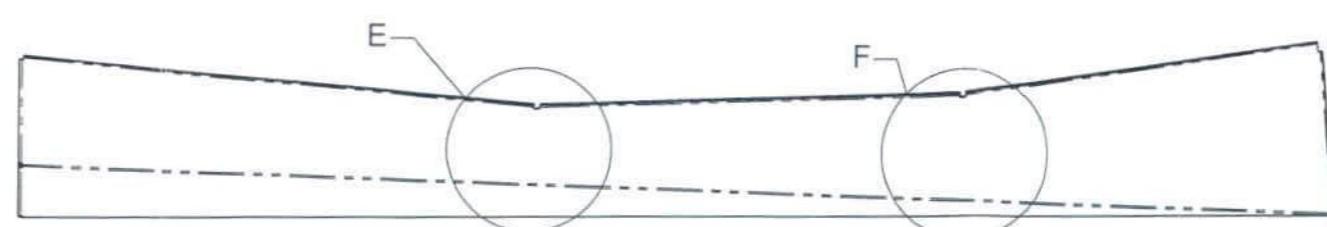
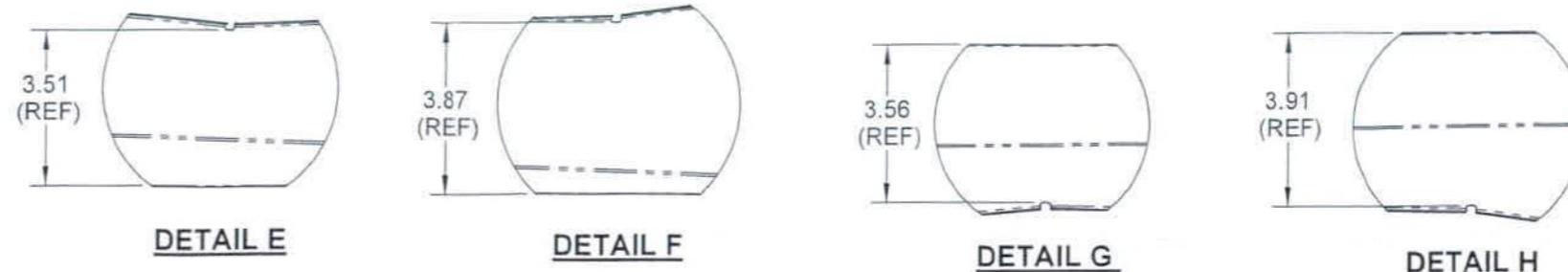
C



SECTION D-D

B

A



D3649-1 TUNNEL BOTTOM PANEL
(MAKE FROM D3649-1F)

RELEASED
08-03-27

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>LF</i>	DRAWING NO.
MFG. APPR.	<i>W</i>	REV. B
APPROVED	<i>W</i>	D3649
DE APPR.	<i>W</i>	SHEET 2 OF 3
DATE	08.01.07	TITLE
		SCALE
		1:6
		COPYRIGHT © 2007 BY DART AEROSPACE LTD
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
		NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
		WRITTEN PERMISSION FROM DART AEROSPACE LTD.



